November 10, 2010 11:48:24 AM

Item ID:	D412-750-141	**Accept**
Revision ID:		
Item Name:	Tail Light Fairing, LH	

Start Date:	11/10/10	**Start Qty:** 4.00	**Cust Item ID:**
Required Date: 11/15/10		**Req'd Qty:** 4.00	**Customer:**
Reference:			

Setup Start
Stop

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start
Stop

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
N/A	Rev A								
100 DC Document Control	DOCUMENT CONTROL	0.00							
	Memo Photocopy bluefile & type labels per PPP D412-750-141 CHG001	0.00							
110 Packaging Packaging	Pick Kit	0.00							
	Memo	0.00							
120 QC Quality Control	QC4- 100% Inspect kits for completeness	0.00							
	Memo ***** Ensure part is a L/H as per dwg *****	0.00							

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Item ID:	D412-750-141		Accept			Setup	Start	
Revision ID:								
Item Name:	Tail Light Fairing, LH						Stop	

Start Date:	11/10/10	Start Qty:	4.00		Cust Item ID:			
Required Date:	11/15/10	Req'd Qty:	4.00		Customer:			
Reference:								

Approvals:	Process Plan:		Date:	Tooling:		Date:	Run	Start
	QC:		Date:	SPC (Y/N):		Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-750-141☐Location:____77____ ☐PPP Rev:__A__								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

November 10, 2010 11:48:23 AM

Work Order ID: 63709

Parent Item: D412-750-141

Parent Item Name: Tail Light Fairing, LH

Start Date: 11/10/10   **Required Date:** 11/15/10
Start Qty: 4.00   **Required Qty:** 4.00

Comments: IPP revA   06.09.22 new issue   EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-3A		Purchased	No			120	Each	159.0000	10	40		10/11/11	
Bolt													

Location	Loc Qty	Loc Code
ST350	159	
113121	2	
114615	1	
115016	56	40
115621	100	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			120	Each	8.0000	10	40	M115622	10/11/11	
Washer													

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3484-041		Manufactured	No			120	Each	10.0000	1	4		10/11/11	
Tail Light Fairing Assembly, LH													

Location	Loc Qty	Loc Code
ST205	10	
53010	10	4

3.8   Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assemlby to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb·in (1.7-2.8 N·m). Refer to Figure 1, Detail A.

4.0   WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141 *Tail Light Fairing Kit, LH*	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m
D412-750-142 *Tail Light Fairing Kit, RH*	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m

5.0   PARTS LIST

Qty – 141	Qty – 142	Part Number	Description
X		D412-750-141	**TAIL LIGHT FAIRING KIT, LH**
	X	D412-750-142	**TAIL LIGHT FAIRING KIT, RH**
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER

Revision: **A**
Date: 05.11.29

5° (REF)

LIGHTLY GRIND/SMOOTH

A

9.43±0.06

$\not{C}$ OF D3484-1

9.25±0.06

$\not{C}$ OF D3484-5

2.25±0.06 /F

2.00±0.06 /F

A
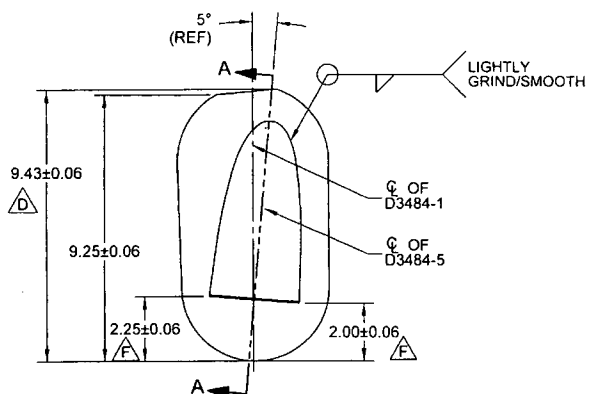
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

5° (REF)

LIGHTLY GRIND/SMOOTH

B

9.43±0.06

$\not{C}$ OF D3484-2

9.25±0.06

$\not{C}$ OF D3484-6

2.00±0.06 /F

2.25±0.06 /F

B

5.20±0.06

2.77±0.06

0.40±0.06

1.46±0.06

6

1.00±0.06

INSTALL MS21069-04 ANCHOR NUT (2 PLACES)

SECTION A-A

INSTALL MS21069-04 ANCHOR NUT (2 PLACES)

SECTION B-B

5.20±0.06

0.40±0.06

2.77±0.06

1.00±0.06

1.46±0.06

6
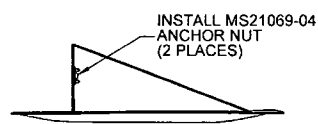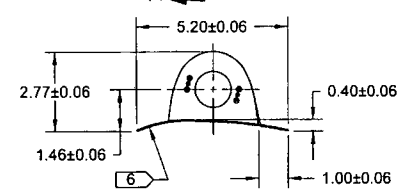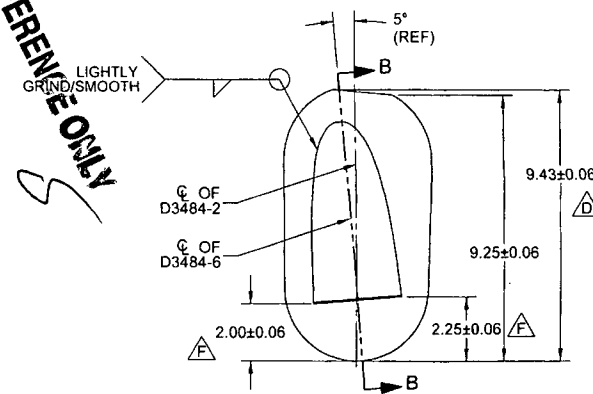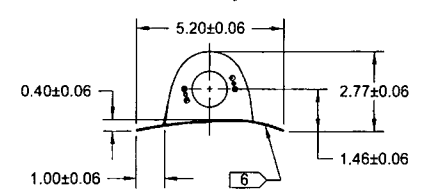
D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING

D3484-1 BASE

D3484-5 CONE

D3484-3 FACE

CR1122-3-02.5 RIVET (4 PLACES)

LIGHTLY GRIND/SMOOTH

G
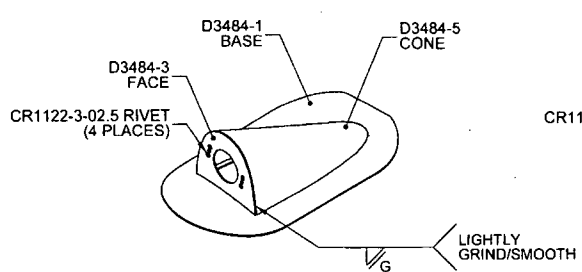
D3484-041 ISOMETRIC VIEW

D3484-2 BASE

D3484-6 CONE

D3484-4 FACE

CR1122-3-02.5 RIVET (4 PLACES)

LIGHTLY GRIND/SMOOTH

G
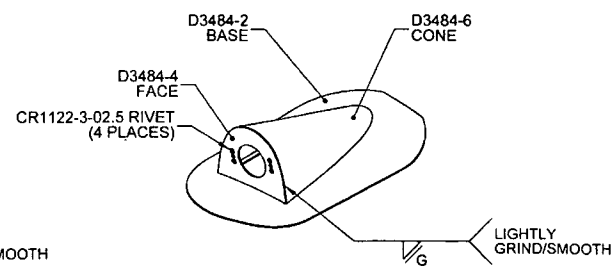
D3484-042 ISOMETRIC VIEW

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) WELDING: PER DART QSI 004
6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
   "TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
7) WEIGHT: 0.30 lbs

RELEASED

REV.	DESCRIPTION	BY	DATE
F	UPDATE MATERIAL SPEC, ADD 6061-0, ZN A7-2, A7-3, B3-4. UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1		09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS), DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:4
DATE 09.03.31		COPYRIGHT © 2005 BY DART AEROSPACE LTD	